

Date: Wednesday, 17/12/2008 1:52:52 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER  
 Job Number : 44151  
 Estimate Number : 12810  
 P.O. Number :  
 This Issue : 17/12/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D36091  
 Drawing Number : D3609 REV.A  
 Project Number : N/A  
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : A  
 Material :  
 Previous Run : 31813 Due Date : 09/01/2009 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : JD 08.12.17  
 Comment : Est Rev:A New Issue 07-03-26 JLM  
 Est Rev:B 08-12-11 as per ECN08-577 DD verified by: EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S22GA

304/316.032 Sheet



Comment: Qty: 1-2357/sf(s)/Unit Total: 4.9430 sf(s)

304/316.032 Sheet

Batch: 1/09/057 IB 9-1-6

2.0

WATERJET

FLOW WATERJET



Comment: FLOW WATERJET

1-Cut as per Dwg D3609

Dwg Rev: A

Prog Rev: A

IB 9-1-6

2-Debur if necessary

IB 9-1-6

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-1-6

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 09/01/07

5.0

PACKAGING #1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST184

S 09/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 17/12/2008 1:52:52 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 44151

Part Number: D36091

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



6

Comment: FINAL INSPECTION/W/O RELEASE

2009/11/07

Job Completion



09.06.07

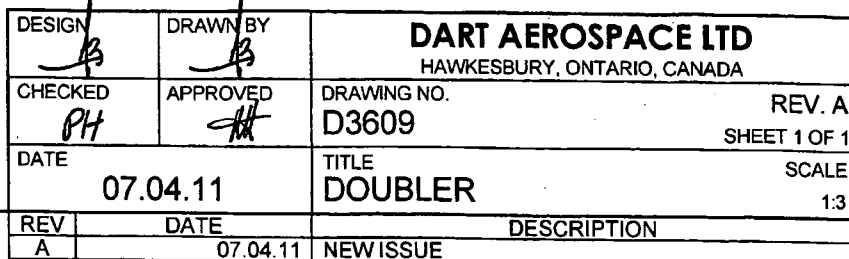
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

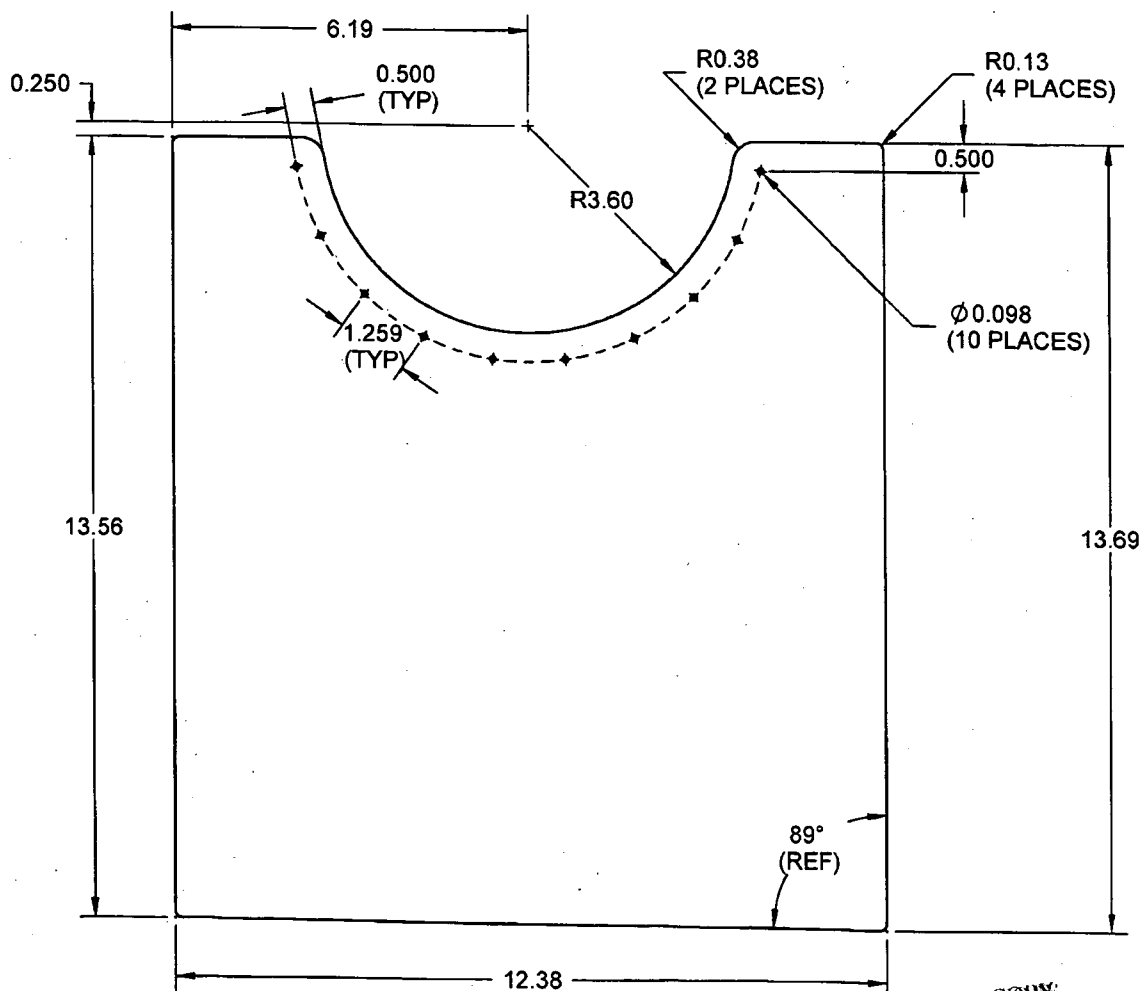
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
08/12/10



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE  
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3609-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\phi$

SMOP COPY  
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ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44751

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